

Patent Abstracts of Japan

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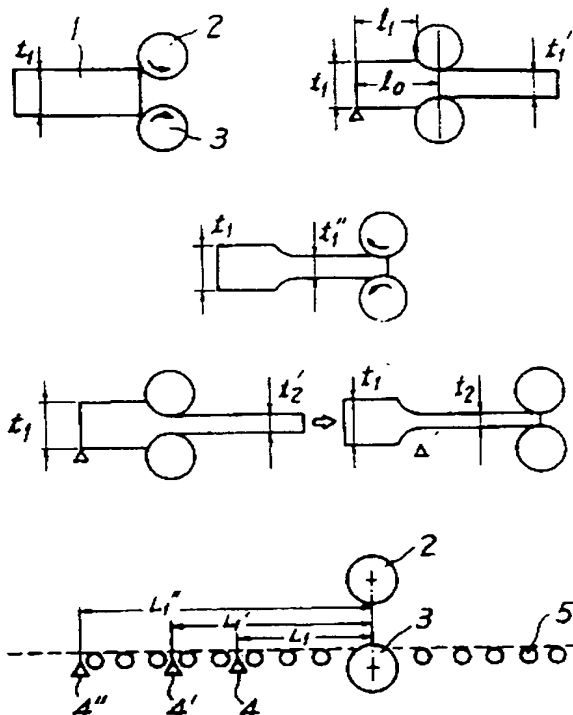
APPLICATION DATE : 08-08-83
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APPLICANT : KAWASAKI STEEL CORP;

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TITLE : ROLLING METHOD FOR PROVIDING
STEP DIFFERENCE TO THICK PLATE



ABSTRACT : PURPOSE: To roll a rolling material into a plate having a large step difference without causing turbulence in its flatness by controlling the advancing and returning rollings of the material, in rolling a rolling material by leaving a part of the material by a prescribed length and rolling the other part into a thinner one through several passes of reversing rollings.

CONSTITUTION: A steel plate 1 rolled into the sheet thickness t_1 is rolled into the sheet thickness t_1' by upper and lower work rolls 2, 3 having a roll gap S_1 between them, and when the top of plate 1 is detected by a steel plate detector 4, the rotation of mill is stopped to leave a thick-plate part having thickness t_1 by a length l_1 . Successively a return rolling is performed by reversing the mill to obtain a thin-plate part having sheet thickness t_1'' . Further, the 2nd pass rolling is performed to obtain a thin plate-thickness t_2' part by regulating the roll gap to S_2 ($S_1 > S_2$), and the mill is reversed when the detector 4 detects the top of plate 1 to obtain a thin plate-thickness t_2 part. In this way, a plate with different thicknesses is obtained, which consists of a part having a prescribed length l_1 and a sheet thickness t_1 and a remaining part having a sheet thickness t_2 .

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